

Claims

What is claimed is:

1. In a thread rolling attachment adapted to be mounted on a machine tool and be selectively moved in an axial direction relative to a workpiece having a cylindrical surface upon which a thread is to be rolled, said attachment having a spring housing, a sun gear rotatably mounted on said spring housing, three planetary gears engaging said sun gear at equidistant locations thereabout, and a helical spring acting between said spring housing and said sun gear, the improvement comprising:
 - 10 a center plate having three circularly-spaced detents;
 - a front plate having a central portion arranged in axially-spaced relation to said center plate and having three circularly-spaced lugs extending toward said center plate such that the distal end surfaces of said lugs are adapted to engage said center plate;
 - 15 a recess extending into each lug from said distal surface, each recess adapted to receive a respective one of said detents for angularly orienting said center and front plates relative to one another;
 - three eccentric roll pins having their opposite marginal end portions journalled on said center and front plates, and spaced equally from one another about an imaginary circle;
 - 20 a thread roll rotatably mounted on each eccentric roll pin; and
 - a plurality of fasteners operatively arranged to selectively hold said center and front plates together;
 - whereby, when said thread rolling attachment is assembled, said front
 - 25 plate will have improved rigidity and will be less susceptible to deformation.
2. The improvement as set forth in claim 1 wherein said center and front plates are provided with a low friction coating.

3. The improvement as set forth in claim 1 wherein the axis of said roll pins is skewed with respect to the axis of said workpiece cylindrical surface.
4. The improvement as set forth in claim 1 and further comprising a carbide bushing operatively arranged between each thread roll and the associated roll pin.